

must ship July 30

Work Order ID 60775



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Thursday, July 22, 2010 1:00:30 PM

Item ID: D4148-3
Revision ID: PRELIM
Item Name: Stud Receiver, Lower

Accept



Setup Start

Stop



Start Date: 7/22/2010 Start Qty: 4.00
Required Date: 7/29/2010 Req'd Qty: 4.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *PA*
QC: _____

Date: *10-7-22* Tooling:
Date: _____ SPC (Y/N): _____

Date: _____
Date: _____

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	<i>PAI Rev B 10-07-22</i>								
100	Cut blanks as per folio	0.00							
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	5.700" LONG								
110		0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MACHINE AS PER FOLI FA944 AND DWG								
	FOLIO REV: <i>1A</i>								
	DWG REV: <i>13</i>								
	DEBURR								

af 10-7-26

4

af 10-7-26

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4148-3	Accept		Setup	Start	
Revision ID: PRELIM				Stop	
Item Name: Stud Receiver, Lower					
Start Date: 7/22/2010	Start Qty: 4.00				
Required Date: 7/29/2010	Req'd Qty: 4.00				
Reference:					
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run
	QC:	Date:	SPC (Y/N):	Date:	Start
					Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>af 10.7.26</i>					
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>SP 10/07/26</i>		<i>4</i>	<i>/</i>		
170 Packaging Packaging	Identify as per dwg & Stock Location: <i>GA</i> <i>B 60774</i> Memo	0.00 0.00		<i>SP 10/07/26</i>		<i>(4)</i>			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60775

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Item ID: D4148-3

Accept

Revision ID: PRELIM

Item Name: Stud Receiver, Lower

Start Date: 7/22/2010 Start Qty: 4.00

Required Date: 7/29/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/07/07

10-7-27
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 22, 2010 1:00:46 PM

Page 1

Work Order ID: 60775

Parent Item: D4148-3

Parent Item Name: Stud Receiver, Lower



Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.500X03.000		Purchased	No			100	f	9.4947	0.48	2.021053			



303 Bar



Location

MAT53

Loc Qty

9.4947

9.4947

Loc Code

112142

1.91

af 10.7.25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 60775
Description: STUD RECEIVER LOWER		Part Number: 04148
Inspection Dwg:	Rev: 3	Page 1 of 1

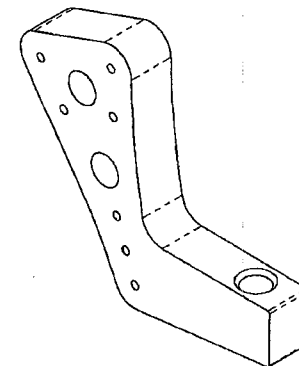
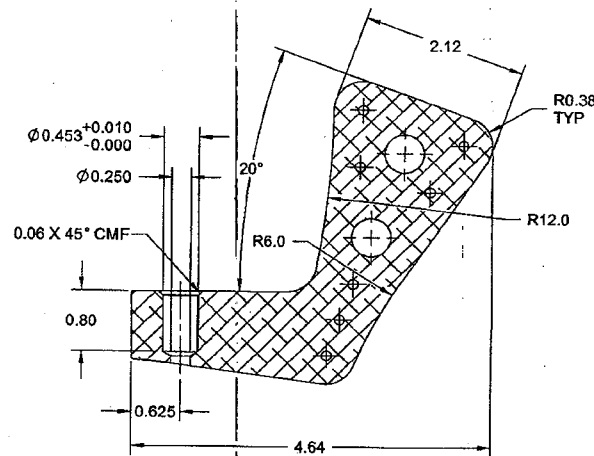
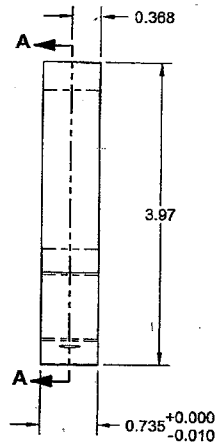
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.94	+/- .030	.978	/		Vern.	
.50	+ .006 - .001	.501	/			
.129	+ .005 - .001	.129	/			
.65	+/- .030	.652	/			
.375	+/- .010	.374	/			
.750	+/- .010	.750	/			
2.284	+/- .010	2.284	/			
1.000	+/- .010	1.000	/			
.500 pitch	+/- .010	.500	/			
.368	+/- .010	.367	/			
3.97	+/- .030	3.97	/			
.735	+0 - .010	.732	/			
2.12	+/- .030	2.120	/			
R.38	+/- .030	R.38	/			
.453	+ .010 - 0.0	.455	/			
.1250	+ .006 - .001	.1250	/			
.06 x 45°	+/- .030	.065	/			
.80	+/- .030	.798	/			
.625	+/- .010	.625	/			
4.64	+/- .030	4.64	/			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 10.7.26	Date: 10/07/26	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15




D4148-3 STUD RECEIVER LOWER

RELEASE
2010-07-16

- NOTES:**
 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
 REF DART SPEC MS304B OR MS303B
 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 1.44 lbs

x 4

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
~~WORK ORDER~~

DESIGN			DART AEROSPACE LTD	
DRAWN			HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV.
MFG. APPR.			D4148	SHEET 4 OF 4
APPROVED			TITLE	SCALE
DE APPR.			FWD X-TUBE LUG ASSY	NT
DATE	10.07.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS TO BE USED ONLY FOR THE PROJECT IT WAS DESIGNED FOR AND NOT BE REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		

WORK ORDER
NO. 66775
8810-7-22